

B1
put onto a die having a bore. A conical rim hole punch presses the two stacked plates into the die. During this movement of the rim hole punch, the two plate-shaped bodies lying on each other are substantially conically deformed, wherein in the area of the front face of the rim hole punch at the plate-shaped body facing the rim hole punch, high tensile stresses occur which effect a breaking out or punching out of a disk-shaped part of this plate-shaped body at the front face of the rim hole punch. In the further course of the movement of the rim hole punch, the plate-shaped body facing the die is deformed further, which causes it to tear out in the area of the edge of the die. The torn-off part is basically cup-shaped and falls off the rest of the plate, wherein at the same time the disk-shaped residual piece of the plate-shaped body facing the rim hole punch falls off. The rim hole is subsequently flanged to join both plate-shaped bodies. In this method, a punching of the plate-shaped body facing the rim hole punch and a subsequent break-out of the plate-shaped body facing the die takes place. This method therefore requires a rimhole punch formed as a punching tool. Moreover, the power ratios must be very balanced to ensure a correct course of the process. Since a punching process must be performed prior to the formation of a rim hole, the forces to be acted on the rim hole punch are very high. --; and

in line 7, delete "Such" and substitute -- Further --.

On page 2, line 5, please delete "Such a method is" and

substitute -- Methods of this kind are --;

in lines 12-13, delete "reduce the number of work steps in the method for producing a riveted joint, to";

B3 in lines 16-22, delete all of the text starting with "by having formed", through the end of the paragraph, and substitute -- in that prior to formation of the rim hole a penetration opening is created through the pile whose cross-section surface corresponds at most to the cross-section surface of the opening of the rim hole. -- ~~and~~

B3 in lines 23-28, delete all of the text starting after "The solution is simple", through "can thus be dispensed with," and substitute -- and has the advantage that the individual work steps are easy to handle. First of all, the penetration opening is formed before the forming process is carried out. The manufacture of the penetration opening can for instance be made by a common drilling in a known manner. The forces to be acted on the rim hole punch can be lower, since the forming of the plate-shaped bodies is facilitated due to the penetration bore. On the whole the new method becomes more profitable.

The --.

On page 3, lines 21-27, please delete the entire paragraph, beginning "In an advantageous embodiment of the invention" through "maximum plastic distortion."

IN THE CLAIMS:

B4 ~~Sub 1~~ (Twice Amended). Method for producing a rim hole through